

Date: Thursday, 7/12/2007 10:40:14 AM
 User: Kim Johnston

Process Sheet

31

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	FLOAT SKID ASSEMBLY		
Job Number	33525A			Part Number	D412742043		
Estimate Number	10756			Drawing Number	D3391 REV F		
P.O. Number	N/A			Project Number	N/A		
This Issue	7/12/2007 S.O. No. N/A			Drawing Revision	F		
Prsht Rev.	NC			Material	N/A		
First Issue	N/A Type LANDING GEAR			Due Date	7/30/2007 Qty: 1 Um: Each		
Previous Run	33442A						
Written By							
Checked & Approved By							
Comment	Est Rev A 05.10.13 New Issue Est Rev B 06.02.13 ECN 773 dwg @ rev.D Est Rev:C 07-05-28 As per Rev F			KJ/JLM EC JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL If D412-742-043 is a W/O on its own, Photocopy bluefile and create labels per PPP D412-742-043 CHG003		
2.0	D3391023	Mid Tube Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) pick: Qty Part Number Description Batch 1 D3391-023 Mid Tube Assembly <u>132237</u> <u>M</u>		
3.0	D3391025	Aft Tube Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) pick: Qty Part Number Description Batch 1 D3391-025 Aft Tube Assembly <u>133644</u> <u>M</u>		
4.0	D35641	WEARSHOE
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARSHOE Batch: <u>1333243</u> <u>M</u> <u>07-08-14 Y1</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/12/2007 10:40:14 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33525A

Part Number: D412742043

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	D35643	WEARSHOE
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
	WEARSHOE	
	Batch: 133761	11
6.0	D35645	WEARSHOE
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
	WEARSHOE	
	Batch: 133802	11
7.0	D35661	GASKET
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	GASKET	
	Batch: 133458	11
8.0	D35665	GASKET
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
	GASKET	
	Batch: 133483	11
9.0	AN3C4A	BOLT
	Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)	
	BOLT	
	Batch: M105057	11
10.0	AN3C6A	BOLT
	Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)	
	BOLT	
	Batch: M103693	11
11.0	AN3C7A	BOLT
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)	
	BOLT	
	Batch: M1103668	11 07-08-16 X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33525A

Part Number: D412742043

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 AN960C10L washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

washer

Batch: M105143

em

13.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3 M105085

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/291 M104989

Expiry date: 08-01

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R LPS Procyon M104751

A/R Sikaflex-241/291 M104989

Expiry date: 08-01

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

M104989

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M104989

15.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location:

PPP Rev: PPP 33563

7/12/07/2007

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/08/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/12/2007 10:40:14 AM
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Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33525A

Part Number: D412742043

Job Number:



Seq. #: Machine Or Operation:

Description :

16.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
D07/08/22

Job Completion



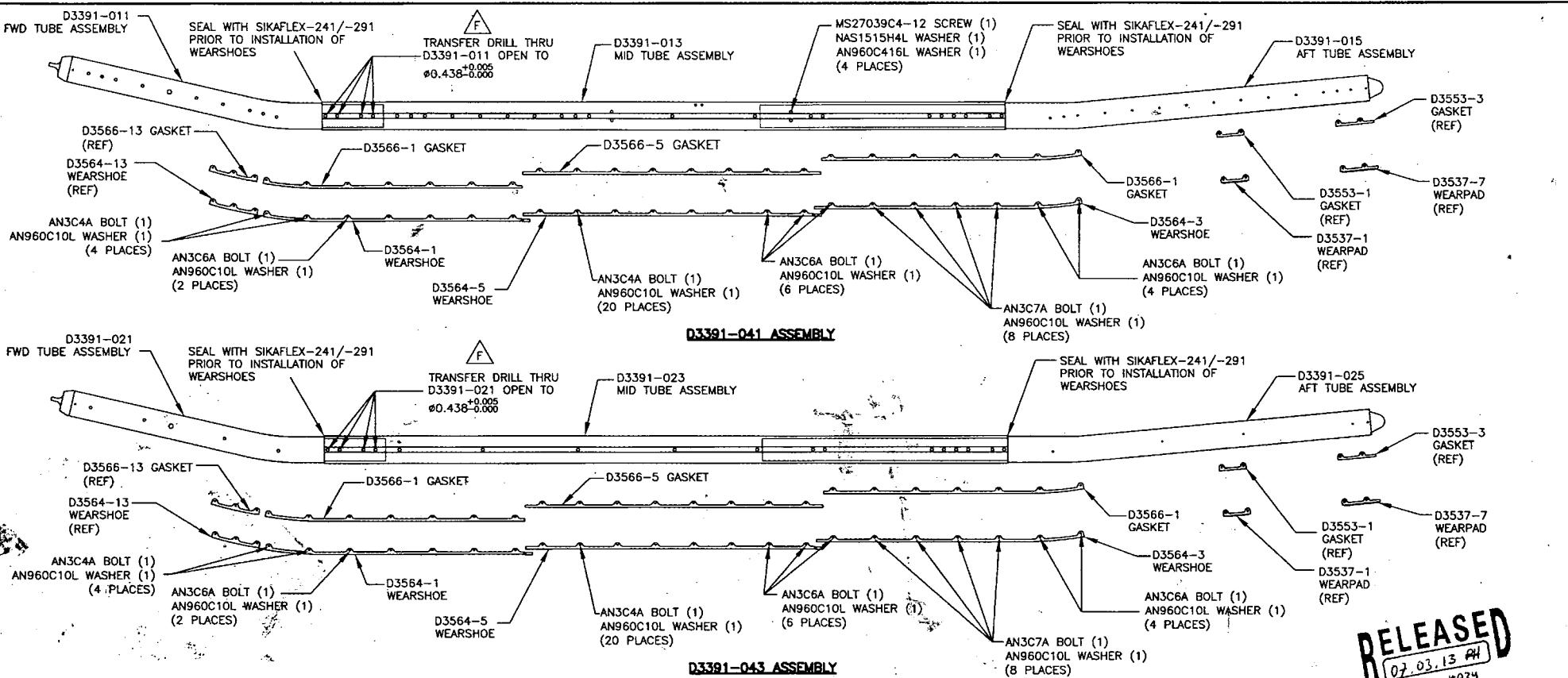
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
07.03.13 PH
per E&N #8934

D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-043	D3391-041	FLOAT SKIDTUBE ASSEMBLY
X	X	D3391-043	* FLOT SKIDTUBE ASSEMBLY
1	1	D3391-011	FWD TUBE ASSEMBLY
1	1	D3391-013	MID TUBE ASSEMBLY
1	1	D3391-015	AFT TUBE ASSEMBLY
1	1	D3391-021	FWD TUBE ASSEMBLY
1	1	D3391-023	MID TUBE ASSEMBLY
1	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3564-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4	4	MS27039C4-12	COPR
4	4	NAS1515H4L	WASHER
4	4	AN960C10L	WASHER

GENERAL NOTES

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES ($\phi 0.250$ – $\phi 0.257$) FOR WEARSHOE INSERTS. C-SINK $\phi 0.391$ / $\phi 0.425$ x 100° AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

UNCONTROLLED COPY
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WORK ORDER
N
3525A

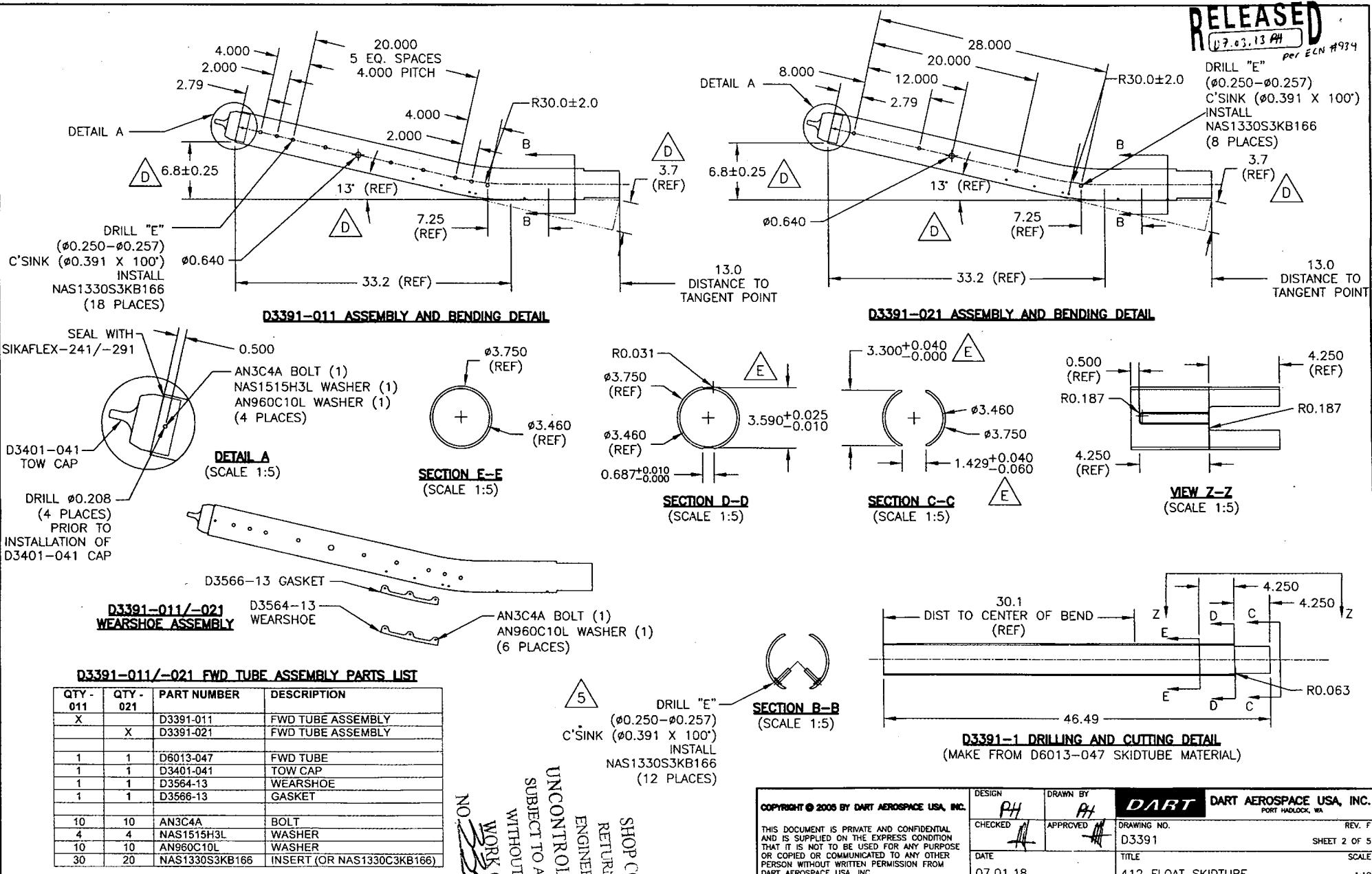
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RETURN TO
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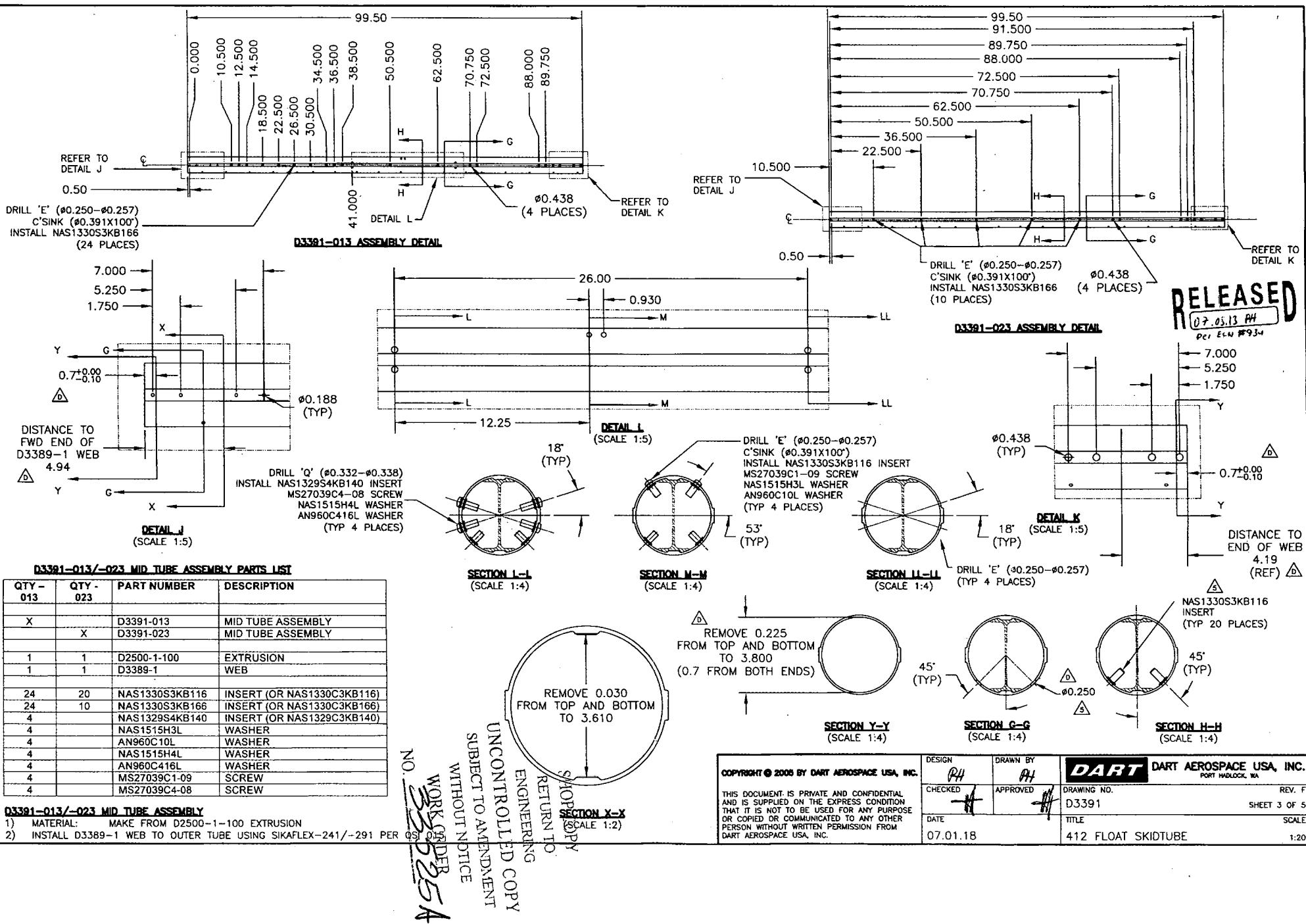
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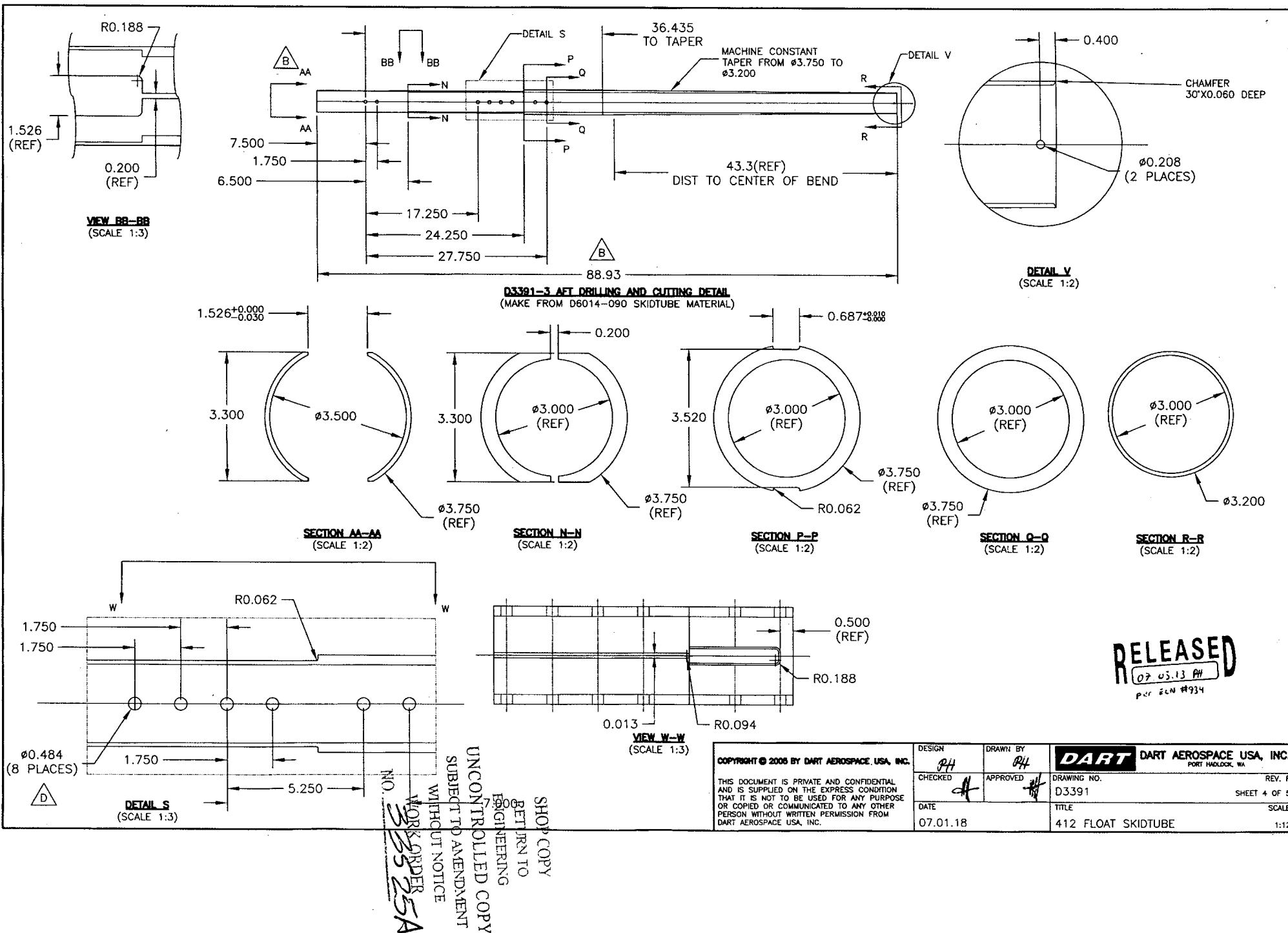
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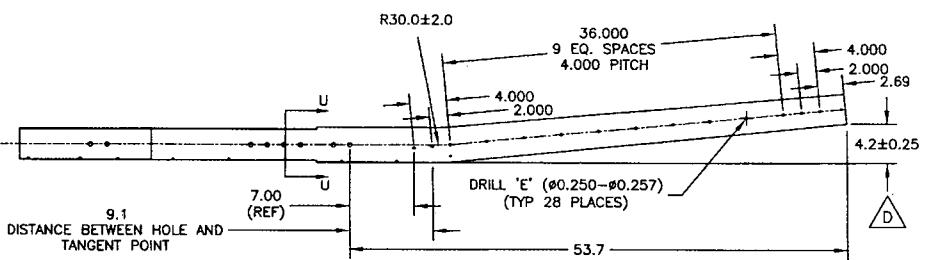
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E	06.04.25	CHANGE TOLERANCE,EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
REVIEWED	APPROVED	DRAWING NO. REV. F D3391 SHEET 1 OF 5
DATE	07.01.18	TITLE SCALE 412 FLOAT SKIDTUBE NTS

RELEASED
07.03.13 AM
per ECN A934

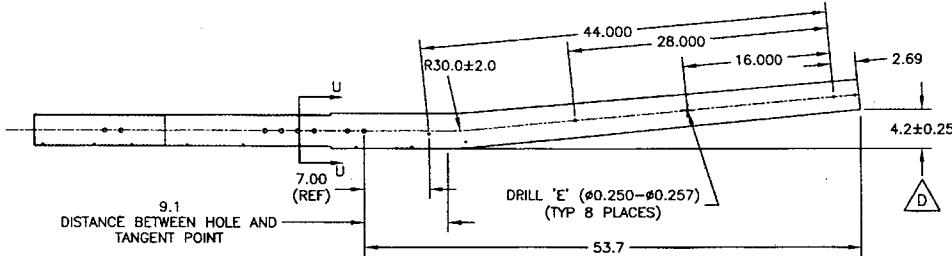




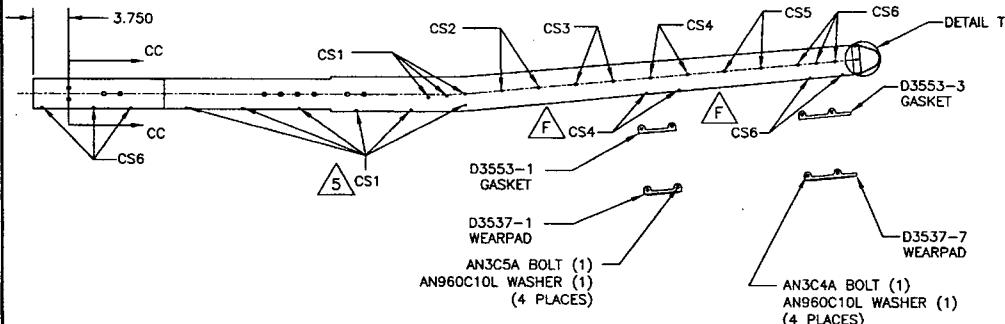




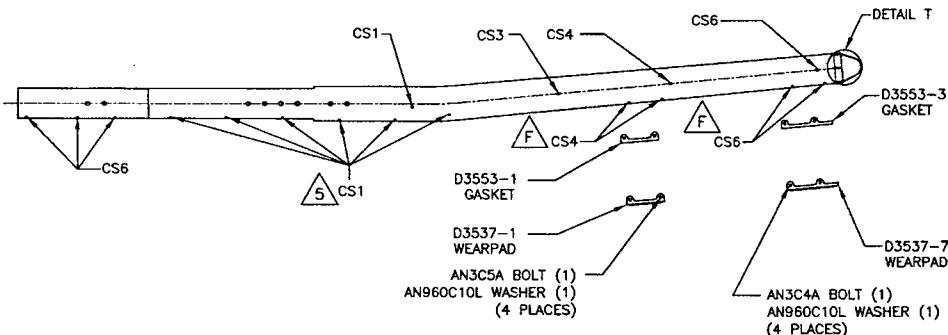
D3391-015 BENDING AND ASSEMBLY DETAIL



D3391-025 BENDING AND ASSEMBLY DETAIL



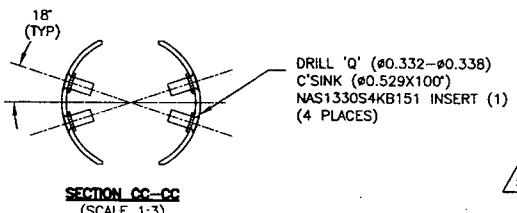
D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)



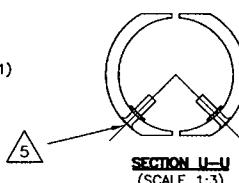
D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)

RELEASED
07.03.13 PM
FBI #934

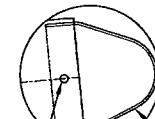
D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST			
QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4	4	NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4	4	NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER



SECTION CC-CG



SECTION II—I



(S) **DETAIL I**
(SCALE 1:1)

- SEAL WITH
SIKAFLLEX-241/-291

C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4	1	Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	1	1	Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3391	REV. F SHEET 5 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE		SCALE 1:12

RE: R
COPY
ANTO
ENG
COPY
TO MANAGEMENT